

order 9851 X1 Ship 17 Oct
order 9852 X1



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D412-698-013
Job Sheet 183758



Part No: D412-698-013 **Job Qty:** 2 ea

Part Name: Cabin Door Handle - Aluminum Door



Part Weight: 0 lbs **Status:** Scheduled **Priority:** Medium

Job Created: 9/26/18 **Job Tracking No:**

Due Date: 10/17/18 **Created By:** Marie Lajeunesse

Type: SOLD **Description:**

Note: IIN-D412-698 REV.G IPP Rev: C Removed Manufacturing 05-11-06 JLM IPP Rev:D change to rev D ECN 1104 08-01-28 DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	10/17/18	10/17/18	0.00	0.00	Start Up Stores/Pkg-2		OCT 01 2018
110	Packaging	2 pcs	10/17/18	10/17/18	0.00	0.00	Packaging1-4		OCT 01 2018
120	QC	2 pcs	10/17/18	10/17/18	0.00	0.00	QC4		OCT 01 2018
130	Packaging	2 pcs	10/17/18	10/17/18	0.00	0.00	Packaging3-2		OCT 01 2018
135	DC	2 pcs	10/17/18	10/17/18	0.00	0.00	DC		OCT 01 2018
140	QC21-FG	2 Ea	10/17/18	10/17/18	0.00	0.00	QC21		OCT 01 2018

Part Op Descriptions: 135 - Photocopy bluefile and create labels per PPP D412-698-013 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3203-1	Handle	8 Ea (4 ea)	90-Start up Operation	5112764
D3220-041	Doubler Assembly	2 Ea (1 ea)	90-Start up Operation	5035718 X1 510921321
D3220-042	Doubler Assembly	2 Ea (1 ea)	90-Start up Operation	5070349
D3220-3	Doubler	4 Ea (2 ea)	90-Start up Operation	5102370
MS21042L4	Nut	16 Ea (8 ea)	90-Start up Operation	5094597
MS24694-S98	Screw	32 Ea (16 ea)	90-Start up Operation	5100410
NAS1149D0463J	Washer	16 Ea (8 ea)	90-Start up Operation	5100410

5089299

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3203-1	8	9	0
	D3220-041	2	3	0
	D3220-042	2	4	0
	D3220-3	4	8	0
	MS21042L4	16	4,437	0
	MS24694-S98	32	172	0
	NAS1149D0463J	16	6,590	0

Part Specifications

Specifications could not be found.

5718

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐		
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Large Fab ☐	Composite ☐	Supplier ☐																				
Date : _____ Dart Aerospace Ltd. 1270 Aberdeen Street Markham, ON L3R 9K7 TEL : 1 813 832-5200 Email: sales@dartaero.com www.dartaerospace.com	Step #: _____ Order Deviation _____	QTY Effective : _____ Disposition _____	MRB (QSI042) Approval _____ Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																			
 Container No: S114772 Part: D412-698-013 Job No: 183758 Serial No/Batch: S114772 Revision: G Inspector: _____ Exp Date: _____ Instructions: TC STC SH92-43 Issue 5 Ref: FA0667C SRD1446NY 08/02/08, EASA S	<table style="width:100%; border: none;"> <tr> <td style="border: none; width: 33%;"> ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter </td> <td style="border: none; width: 33%;"> ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes </td> <td style="border: none; width: 33%;"> ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center </td> <td style="border: none; width: 33%;"> ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence </td> </tr> </table>				☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter	☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence														
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6.0 PARTS LIST – CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Qty -027	Qty -028	Part Number	Description
X								D412-698-011	CABIN DOOR ROLLER KIT, LH
	X							D412-698-012	CABIN DOOR ROLLER KIT, RH
		X						D412-698-013	DOOR HANDLE KIT
			X					D412-698-017	REPLACEMENT DOOR TRACK KIT
				X				D412-698-019	BEARING OVERHAUL KIT
					X			D412-698-021	REPLACEMENT SHIM KIT
						X		D412-689-027	BRACKET KIT, LH (ALUMINUM DOORS)
							X	D412-689-028	BRACKET KIT, RH (ALUMINUM DOORS)
3	3							D3121-141	BRACKET ASSEMBLY
1								D3121-143	BRACKET ASSEMBLY
	1							D3121-144	BRACKET ASSEMBLY
1	1							D3137-043	BRACKET ASSEMBLY
1								D3183-043	BRACKET ASSEMBLY
	1							D3183-044	BRACKET ASSEMBLY
9	9		9					D3199-1	BRACKET
						1		D3199-3	FORWARD BRACKET, LH
							1	D3199-4	FORWARD BRACKET, RH
1	1		1					D3202-1	COVER
		4						D3203-1	HANDLE
		1						D3220-041	DOUBLER
		1						D3220-042	DOUBLER
		2						D3220-3	DOUBLER
				7				D3121-21	BOLT
				5				D3121-241	BEARING ASSEMBLY
				1				D3137-3	GUIDE
				1				D3137-5	WASHER
				2				D3183-045	BEARING ASSEMBLY
					3			D3238-1	SHIM
					1			D3238-3	SHIM
					2			D3238-5	SHIM
					6			D3238-11	SHIM
					2			D3238-13	SHIM
					4			D3238-15	SHIM
		8						NAS1149D0463J	WASHER (AN960JD416L)
		8						MS21042L4	NUT (OR MS21042-4)
		16						MS24694-S98	SCREW
				1				MS24694-S101	SCREW

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Revision: **G**

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